

Work Order ID 50563

July 15, 2009 1:43:01 PM

ASAP



Page 1

Item ID: D3506-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 7/17/09 Start Qty: 20.00



Cust Item ID:

Required Date: 7/20/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:  Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|-------|
| D3506 | Rev A |
|-------|-------|

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3506 I Dwg Rev: A I Prog Rev: A I 12-
Deburr if necessary

M 09 07 15

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

M 09 07 15

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA640 and Dwg D3506

sf 09/07/16 (20)

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00

8/09/07/16

QC

Memo

0.00

Quality Control

140

QC8- Inspect parts - second check

0.00

QC

Memo

JK 09/07/16

0.00

Quality Control

150

Small Fab

0.00

Small Fab

Memo

C'sink as per Dwg D3506(On Flat side)

0.00

8/09/07/16 (20)
Debur m-k 09/07/15

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Page 3

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Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



⇒ 801/07/16

canter
(420)

φ

UMP 09/07/16 (x20)

BR 09-07-16 (20)

Work Order ID 50563

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Start Qty: 20.00



Cust Item ID:

Required Date: 7/20/09

Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

BSM

0.00

Packaging

164/17/09

(20)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/2009

W 09.07.20

Picklist Print

July 15, 2009 1:43:00 PM

Work Order ID: 50563

Parent Item: D3506-3RevA

Parent Item Name: Doubler

Comments:

Start Date: 7/17/09

Required Date: 7/20/09

Start Qty: 20.00

Required Qty: 20.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6S.100 | | Purchased | No | | | 120 | sf | 64.5000 | 0.1642 | | | |



6061-T6 .100 Sheet



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 64.5 | |
| 102201 | 64.5 | |

m.m 09 07 15

| | |
|--|-----------------------------|
| DART AEROSPACE LTD | Work Order: 50563 |
| Description: DOUBLER | Part Number: D3506-3 |
| Inspection Dwg: D3506 Rev: A | Page 1 of 1 |

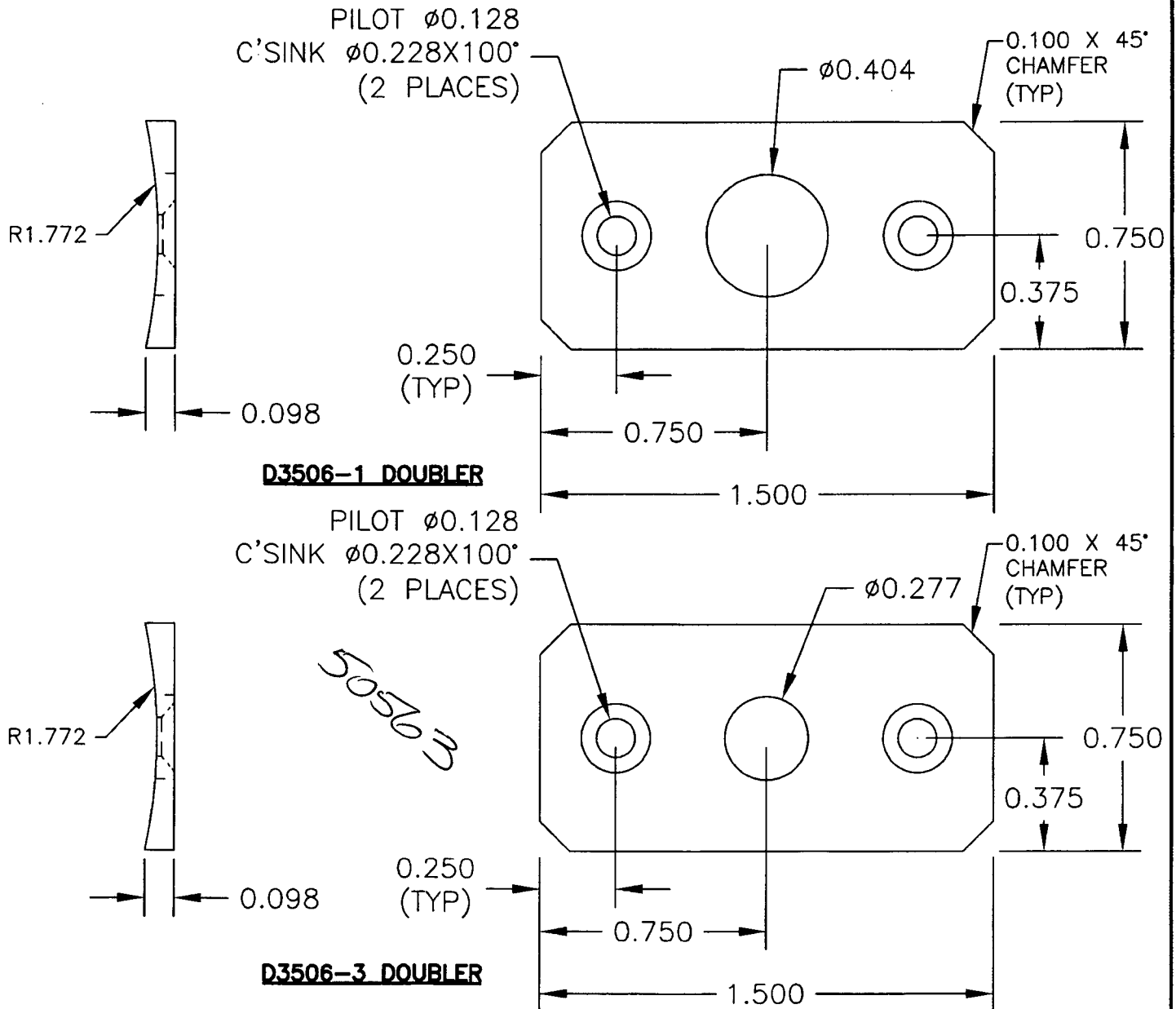
FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

DART

| | | | |
|------------------|----------------|--|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED PH | APPROVED PH | DRAWING NO. D3506 | REV. A SHEET 1 OF 1 |
| DATE 06.04.21 | | TITLE DOUBLER | SCALE 2:1 |
| A | 06.04.21 | NEW ISSUE | |

**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
06.10.03 PH
per ESN #361

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